

Work Order ID 79879

February-07-12 8:32:15 AM

79879

Page 1

Item ID: DSK081 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2940-1 TURNING DETAIL
 Start Date: 06/02/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 21/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/07 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSK081	B

100
100
 Doosan
 Doosan Lathe
 MORI SEIKI CNC LATHE LARGE
 Memo
 Turn blank as per Folio FA079
 0.00
 10 ϕ
 12/2/10

110
110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo
 0.00
 10 ϕ
 12/2/10

120
120
 QC
 Quality Control
 QC8- Inspect parts - second check
 Memo
 0.00
 10 ϕ
 12/02/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>MAT 60</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

amr 12/02/14

10

12/2/15

12-02-14
10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

February-07-12 8:32:19 AM

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Work Order ID: 79879

79879

Parent Item: DSK081

DSK081

Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 06/02/2012

Required Date: 21/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-007		Manufactured	No				Each	18.0000		10			
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D6104-007

Round Billet, 17-4

**

SA

12/2/10

Location

Loc Qty

Loc Code

MAT043

6

76833

6

MAT047

12

77492

12

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	79879
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.954	4.957	4.957	4.955	4.956
C	0.718	0.738		.725	.728	.728	.728	.728
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.575	3.575	3.574	3.574	3.576
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.455	3.454	3.454	3.454	3.454
H	0.112	0.132		.118	.118	.118	.118	.118
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.462	4.462	4.462	4.461	4.461
K	0.413	0.433		.420	.420	.420	.420	.420
L	0.913	0.933		.925	.925	.925	.925	.925
M								
N								
O								
P								

Measured by:  Date: 12/2/10

Audited by:  Date: 12/02/14

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	79879
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.957	4.957	4.958	4.958	4.957
C	0.718	0.738		.725	.725	.728	.728	.725
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.574	3.574	3.575	3.575	3.575
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.455	3.455	3.455	3.455	3.455
H	0.112	0.132		.118	.118	.118	.118	.118
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.462	4.462	4.462	4.462	4.462
K	0.413	0.433		.420	.420	.420	.420	.420
L	0.913	0.933		.925	.925	.925	.925	.925
M								
N								
O								
P								

Measured by: *[Signature]* Date: 12/2/10

Audited by: *[Signature]* Date: 12/02/10

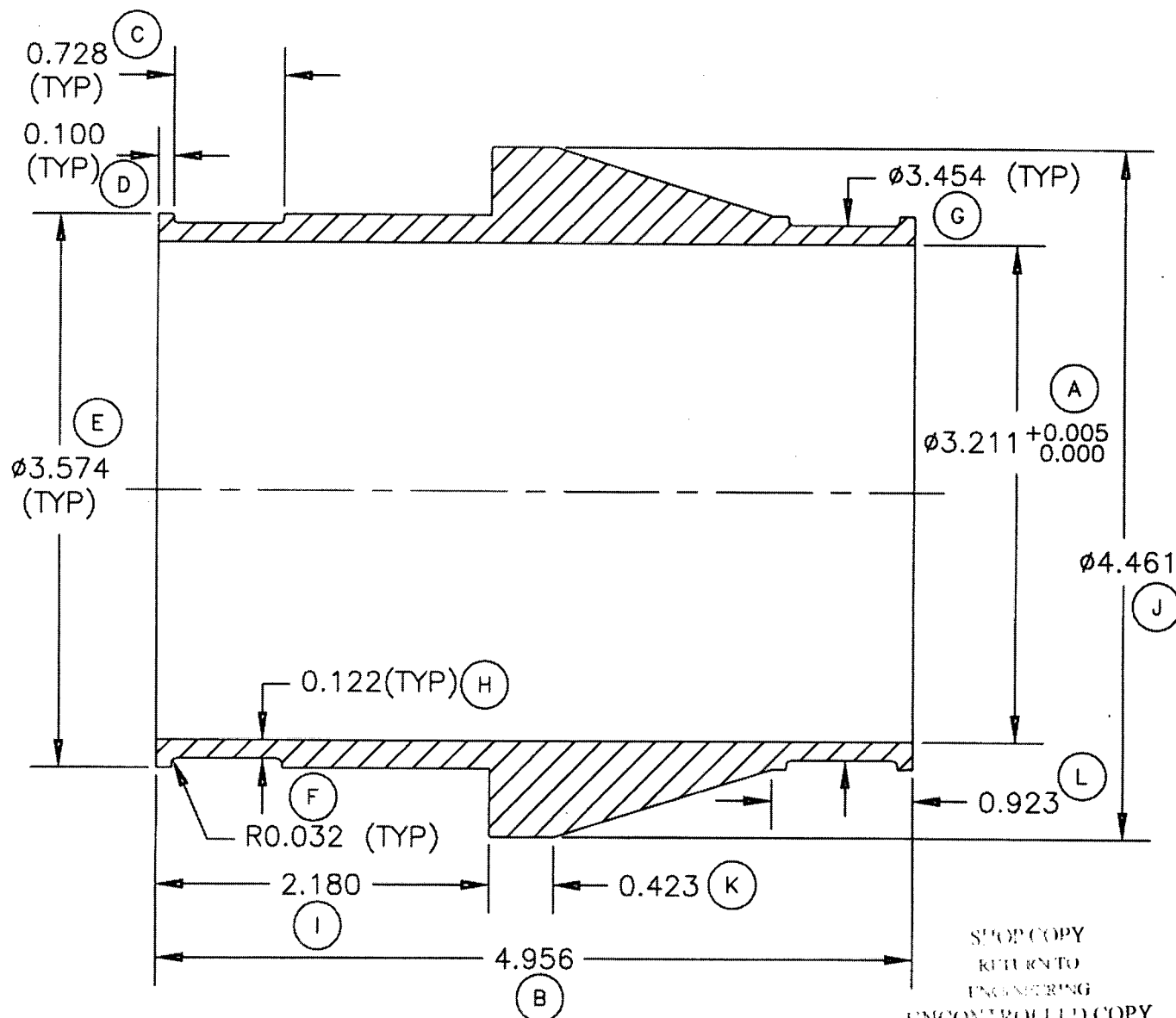
Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED
03.07.01 [Signature]



D2940-1 TURNING DETAIL

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WITHOUT NOTICE
V. C. K. ORDER

NO. 79.879-MLJ
12/02/07

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